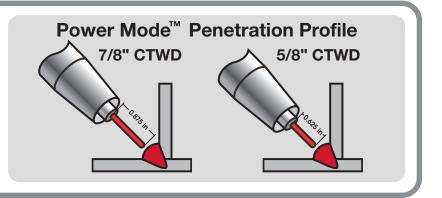
Power Mode[™] Aluminum Welding Process

Power Mode[™] – For Superior Quality Aluminum Welding.

- More consistant weld penetration.
- Fewer fusion defects in welds.
- Provides stable arc performance and less current fluctuation.



A patented process, Power Mode™ uses energy (V x I = W) to regulate the arc length.

Power ModeTM is a process that adjusts the output current in accordance with the difference between the commanded preset power and the actual power. Power ModeTM provides better current stability than CV with spray transfer mode and aluminum welding.

The power supply responds to changes in voltage sensed at the welding arc. However, unlike a Constant Voltage weld process, the Power Mode will respond with less change in current than a Constant Voltage program.

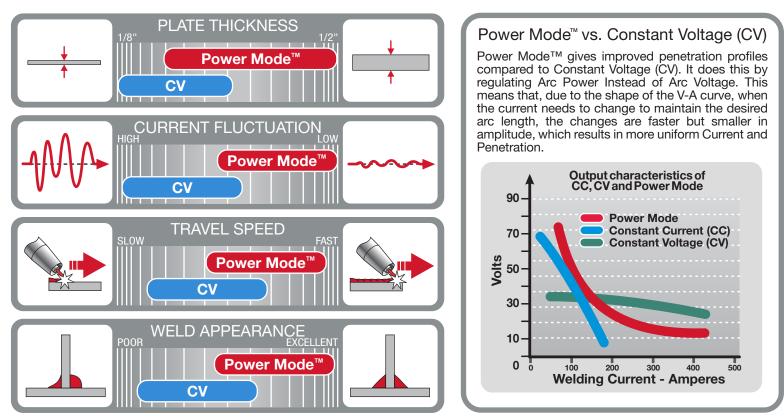
Constant voltage (CV) output characteristic has a slightly negative slope. In comparison with CV output characteristic, same arc length fluctuation will result in smaller current adjustment in CC or Power

power (voltage X current) when there is an arc.

Instead of controlling output voltage, Power Mode controls output

Mode, which will correspond to less effect on penetration. Power Mode aids in the control of the arc's response to variations in stickout. A change in stickout forces a current adjustment so that output power remains constant.

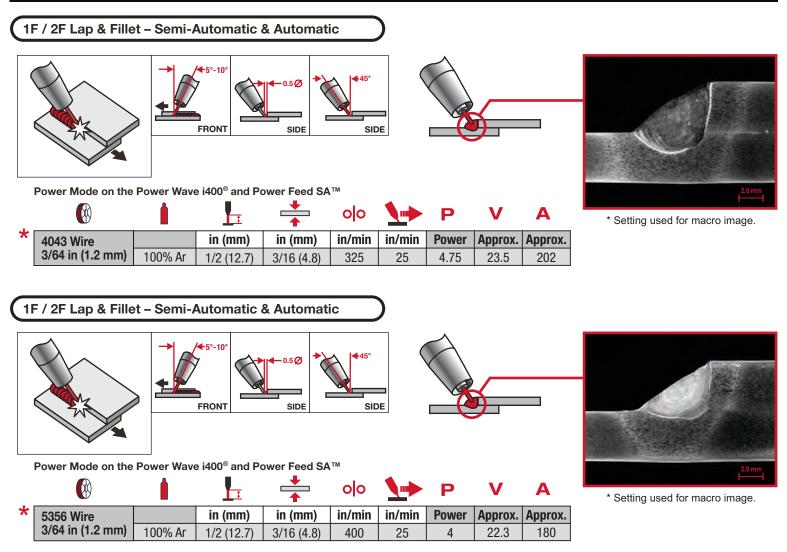
FEATURES



The Performance You Need. The Quality You Expect.

LINCOLN

Applications



*See the Power Mode™ Aluminum Welding Process Guide for: technical data, proper set-up, application settings and troubleshooting.

Recommended Equipment Power Source Wire Feeder Accessories POWER MIG® 350 MP,
Power Wave® C300, S350,
i400 & S500
INVERTEC® V350-PRO Power Feed® 84 or 25M SUPERGLAZE® 4043 TM™
SUPERGLAZE® 5356 TM™

Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customer and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customer's particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirement.

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